

ABSTRACT OF THE DISCLOSURE

A welding shield gas comprising an inert gas and nitrogen gas, where the concentration of the nitrogen gas is 1 to 95 vol%; or comprising an inert gas and a helium gas, where the concentration of the helium gas is 35 to 95 vol%; or comprising an inert gas, nitrogen gas, and a helium gas, wherein the concentration of the nitrogen gas is not less than 1 vol% and less than 65 vol% and the concentration of the helium gas is 35 to 95 vol%. This shield gas can be used in the non-consumable electrode arc welding of a welded material consisting of stainless steel.